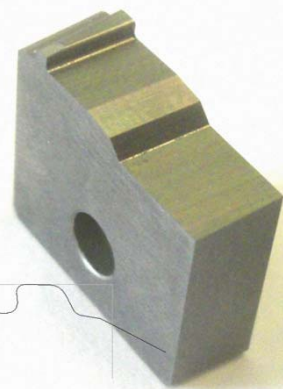


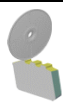






Threadinsert 1-side LxH 15.88 x 15.75

A08-010

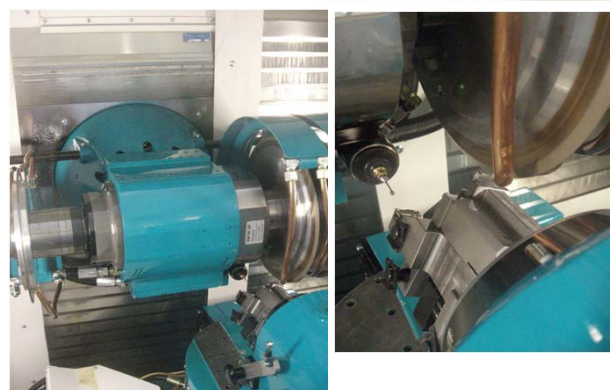
The onesided Threadinsert with single threadform can be ground in one setup in standard RPC or CTC clamping. The plunge roughing operation uses a 1A1 of 2 mm thickness. The pregrinding and finishing operations are using rigid 40 degree V-shaped wheels of diameter 300 mm.



1. Cycletime for Production

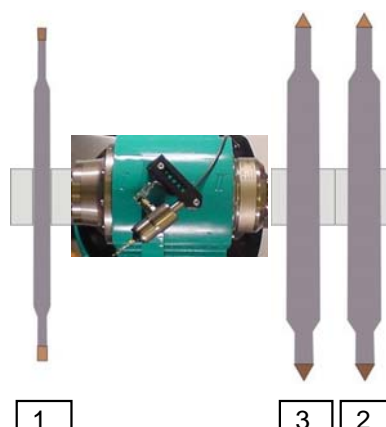
Workpiece: L 15.88 x 15.75 x 4.76 Material CARBIDE				
Operations				
PlungRough				
Pregrinding				
Finishing				
Load				
Feed [mm/Min]	25	25	25	9000
Power [kW]	2	1	2	1
Cutting feed [m/s]	24	24	24	
Used wheels				
Grinding time [s]	166	71	71	15
Total cycle time	5 Min 23			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.



2. Used Grinding Wheels

1	14A1 Ø250 D64
2	14V1 Ø300 D76V40°
3	14V1 Ø300 D64V40°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM
Control: Fanuc 31i
Accessories: STL6051
Responsible engineer: OP. 4.6.10

Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

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